



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5564-5
Job Sheet 182754

Accounting Job RD17-1054-01



Part No: D5564-5

Job Qty: 2 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: R+D

Description:

* Make D5564-5 Rev B as per ECN 18-777 SAT 18-08-31

Note: D5564 REV B PRELIM IPP REV: A 17.11.27 NEW ISSUE DD VERF: JFS IPP REV: B 18.05.02 AS PER DWG
REV: A PRELIM DD VERF: JFS IPP REV: C 18/07/31 AS PER DWG REV: B JFS VERIFIED BY: DP

Ship Via:

POSITIVE RECALL

EFFECTIVE DAS AUTH 21

RELEASED 9 DATE 18-10-03

Priority: Medium
@ Rev B per ECN 18-777

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Waterjet2		SC 18/09/01
110	Waterjet	2 pcs	9/7/18	9/7/18	0.00	0.10	Waterjet1		SC 18/09/01
120	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC2		SC 18/09/01
130	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC8		38
140	Brake NC	2 pcs	9/7/18	9/7/18	0.00	0.10	Brake NC 1		SEP 10 2018 68
150	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC5		SEP 10 2018 68
160	Packaging	2 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3		18-10-03 9-89
170	QC21-SA	2 Ea	9/7/18	9/7/18	0.00	0.00	QC21		OCT 05 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 160 - LOCATION : FP001

DAS
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.0554 sf (.0277 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	341	0

Part Specifications

Specifications could not be found.

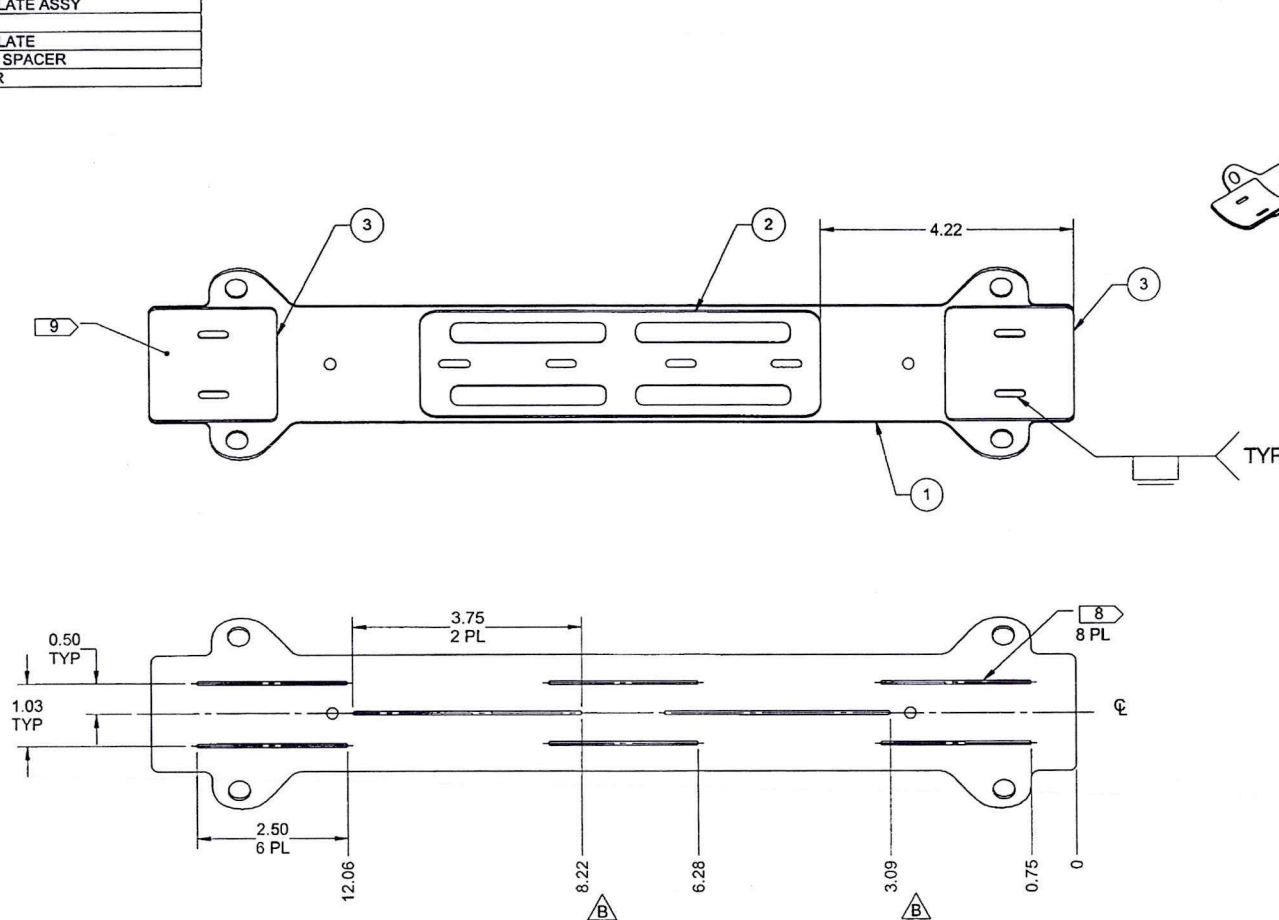
INSPECTION SHEET

DAC
38

9-89

Date:Revised by

ITEM	QTY	P/N	DESCRIPTION
	X	D5564-041	WEARPLATE ASSY
1	1	D5564-1	WEARPLATE
2	1	D5564-3	MIDDLE SPACER
3	2	D5564-5	SPACER



D5564-041 WEARPLATE ASSY

RELEASED

2018 JUL 30 NO
ECN18-777

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.78 lbs
- 8) BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATIC WELDING) OR BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02 - 0.04 THICK PER DART QSI 005 4.9

B	REVISED WELD BEAD LOCATION DUE TO HOLE INTERFERENCE (ZN B3-1, B5-1); REVISED SLOTS (ZN C5-4, C3-5)	VS	18.05.29
A	NEW ISSUE	VS	17.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	DD	D5564	SHEET 1 OF 5
APPROVED	DSW	TITLE	SCALE
DE APPR.	DSW	WEARPLATE	NTS
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- NOTES:
- 1) MATERIAL: MAKE FROM D5564-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSL 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.50 lbs

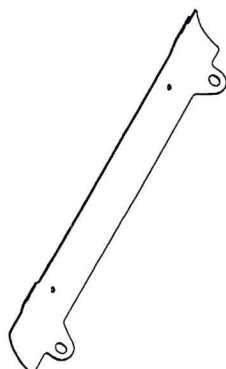
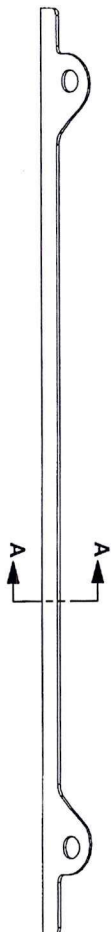
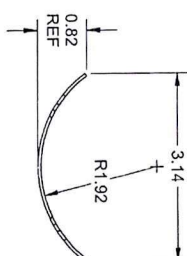
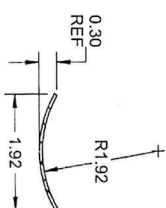
D5564-1 WEARPLATE

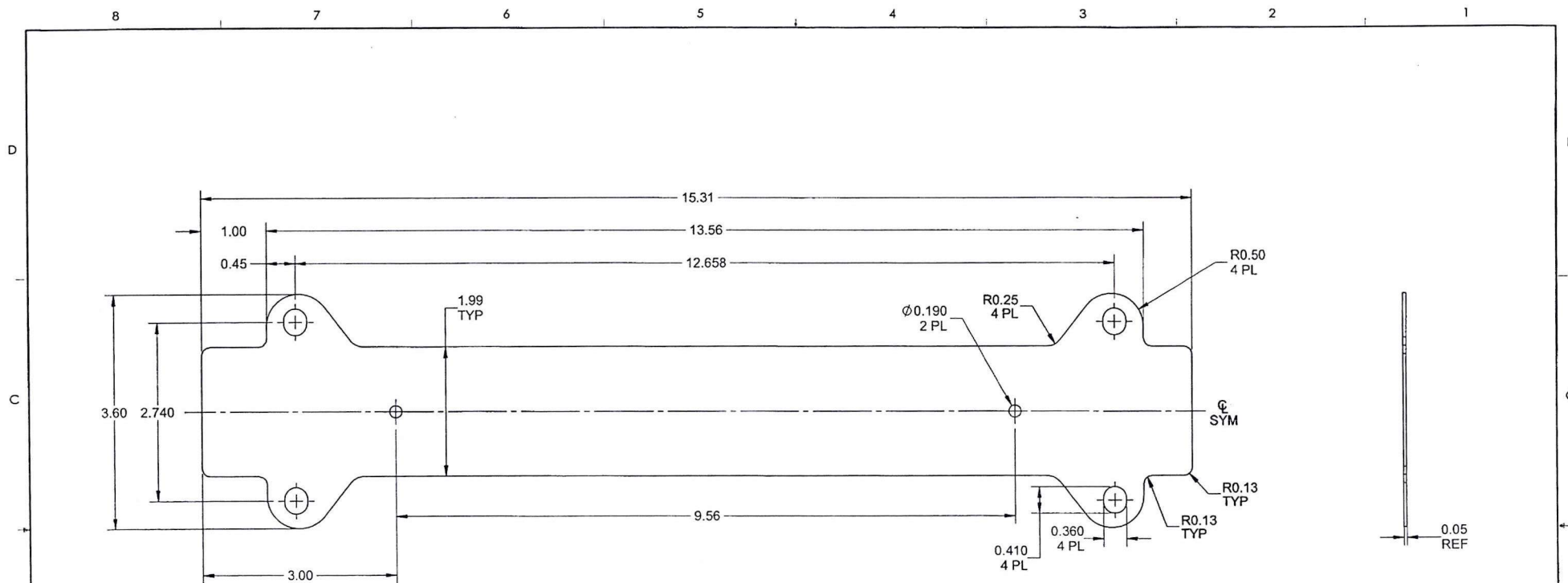
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2018 JUL 30 W0

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DRAWN	VS	HAWKESBURY, ONTARIO, CANADA
CHECKED	WK	DRAWING NO. D5564
MFG. APPR.	DD	REV. B
APPROVED	DSW	SHEET 2 OF 5
DE APPR.	DS	SCALE
DATE	18.05.29	NTS
WEARPLATE		
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SECTION A-A
3 PL





D5564-1F FLAT PATTERN

RELEASED

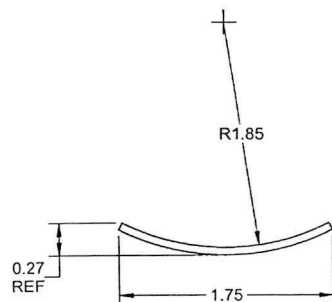
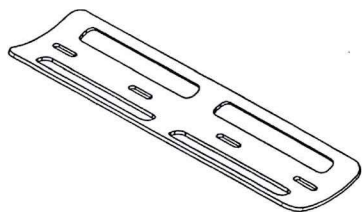
2018 JUL 30 No

NOTES:

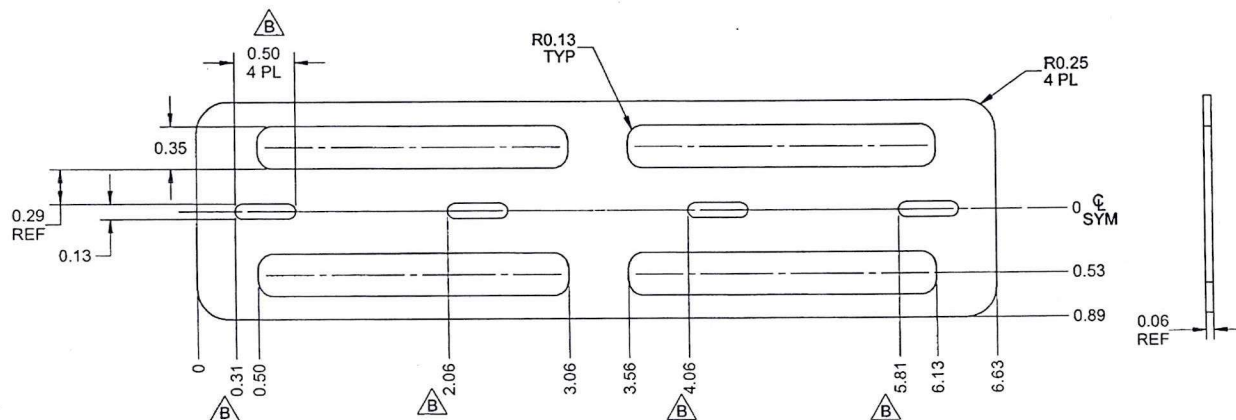
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 18 GAUGE (0.050 THK)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY D5564-1F.DXF REV. B

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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D5564-3 MIDDLE SPACER
(MAKE FROM D5564-3F)



D5564-3F FLAT PATTERN

NOTES:

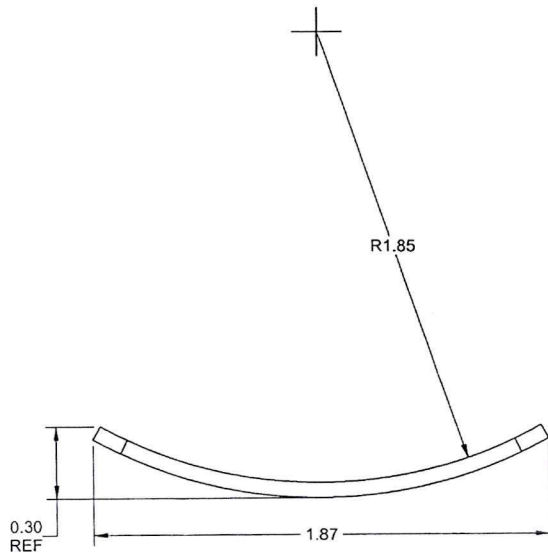
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THK)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY D5564-3F.DXF REV. B

RELEASED

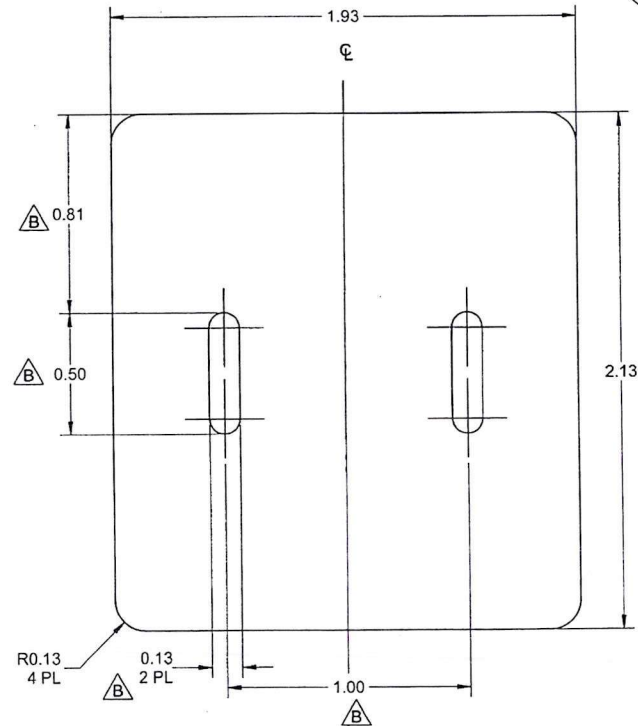
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D5564-5 SPACER
(MAKE FROM D5564-5F)



D5564-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THK)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY D5564-5F.DXF REV. B

RELEASED

2018 JUL 30 No

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